

Work Order ID 140964

Tuesday, January 26, 2016 3:16:48 PM

140964Order to ship Qty 7
skid tubes
March 9.

Page 1

Item ID: D2938-1BL

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle LH Out, 206

Start Date: 1/26/2016 Start Qty: 4.00

4 10 5A
4 10

Cust Item ID:

Required Date: 1/26/2016 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: MUS

Date:

JAN 27 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2938	Rev C								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.05

HAAS CNC vertical machine #1

Program part number and batch number.

- 1-Inspect part number and batch number are programmed correctly.
- 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet
- 3-Machine Step No 2 of Folio and visually inspect as per

10 0 16/02/24

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.01

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

10 0 16/02/24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐		Drawing ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____							
Misidentified ☐		Past Due ☐									

Tuesday, January 26, 2016 3:16:48 PM

140964

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Insp.
Stamp**

120

0.00

Quality Control

0.00

130

0.00

Quality Control

0.00

140

0.00

Hand Finishing

10 0 16/02/24
16/02/24

10 ~~10~~ 16/02/22

10 16-2-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Tuesday, January 26, 2016 3:16:48 PM

1 40964

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 1/26/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 1/26/2016 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

**Insp.
Stamp**

0.00

150

Memo

0.00

SprayPaint

MASK ALL HOLES AS PER PAR16-484

Spray Painting

SPRAY PAINT BLUE
BATCH:

Prime	134188
Paint	134120
Clear	129058

160

QC14- Inspect Spray Paint

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 5310 0.00

0.00

170

Packaging

Memo

0.00

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 140964***140964***

Page 4

Tuesday, January 26, 2016 3:16:48 PM

Item ID: D2938-1BL Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle LH Out, 206
Start Date: 1/26/2016 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 1/26/2016 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									

MCS MAR 03 2016

MCS MAR 03 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QS1042) Approval	
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER : ☐				

Picklist Print

Tuesday, January 26, 2016 3:16:47 PM

Page 1

Work Order ID: 140964

140964

Parent Item: D2938-1BL

***D2938-1BL ***

Parent Item Name: Saddle LH Out, 206

Start Date: 1/26/2016

Required Date: 1/26/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM IPP REV:D 15.10.09
ADDED BL DD VERF:JLM IPP REV:E 16.01.22 PAR16-
484 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	76.0000	1	4			

D6101-003

Saddle Billet, 7075

16/02/18

Location	Loc Qty	Loc Code
MAT045	56	
134038	8	
135957	28	
136764	20	
MAT046	20	
138991	20	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

DART AEROSPACE LTD	Work Order:	140964
Description: 206 Saddle, Outboard, Left side	Part Number:	D2938-1
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.128	0.128	0.128	0.129		
B	0.100	0.140		0.127	0.127	0.128	0.129		
C	0.100	0.140		0.118	0.116	0.116	0.116		
D	0.210	0.230		0.220	0.225	0.225	0.226		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.239	0.239	0.239		
N	0.100	0.140		0.120	0.120	0.120	0.120		
O	0.540	0.560		0.546	0.548	0.548	0.547		
P	0.490	0.510		0.500	0.500	0.500	0.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		0.245	0.251	0.251	0.251		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.317	0.317	0.317	0.317		
X	1.250	1.270		1.263	1.263	1.263	1.262		
Y	1.565	1.585		1.579	1.578	1.578	1.577		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓	✓	✓	✓		

Measured by:	<i>[Signature]</i>
Date:	16/02/22

Audited by:	<i>[Signature]</i>
Date:	16/02/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 140964
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.100	0.140		0.128	0.129	0.130	0.130		
B	0.100	0.140		0.128	0.129	0.130	0.130		
C	0.100	0.140		0.116	0.115	0.116	0.115		
D	0.210	0.230		0.226	0.226	0.225	0.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.511	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.239	0.239		
N	0.100	0.140		0.121	0.121	0.121	0.120		
O	0.540	0.560		0.547	0.548	0.548	0.548		
P	0.490	0.510		0.500	0.500	0.500	0.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.740	2.740	2.740	2.740		
S	0.240	0.270		0.251	0.253	0.253	0.253		
T	0.100	0.180		0.140	0.140	0.140	0.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.317	0.317	0.317	0.317		
X	1.250	1.270		1.263	1.262	1.263	1.263		
Y	1.565	1.585		1.578	1.576	1.577	1.577		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓	✓	✓	✓		

Measured by:	<i>h.s.p.</i>
Date:	16/02/22

Audited by:	<i>SMK</i>
Date:	16/02/25

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order: 140969
Description: 206 Saddle, Outboard, Left side	Part Number: D2938-1
Inspection Dwg: D2938 Rev. C	Page 1 of 1

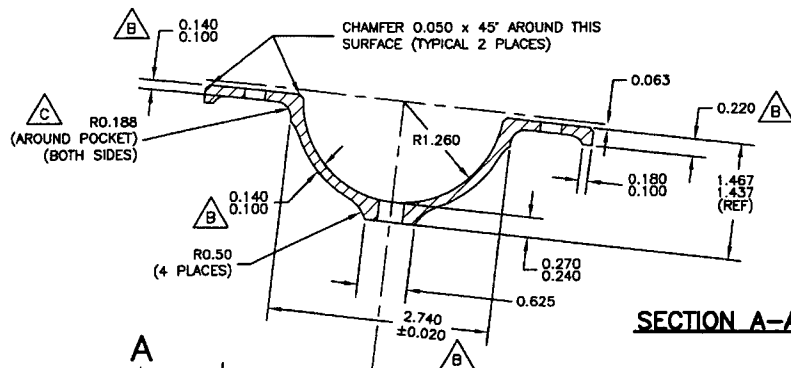
Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				# 9	# 10	3	4		
A	0.100	0.140		0.128	0.123				
B	0.100	0.140		0.128	0.123				
C	0.100	0.140		0.120	0.110				
D	0.210	0.230		0.225	0.215				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		0.512	0.512				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.258	0.258				
L	0.312	0.317		0.314	0.314				
M	0.235	0.240		0.239	0.239				
N	0.100	0.140		0.115	0.108				
O	0.540	0.560		0.550	0.550				
P	0.490	0.510		0.500	0.500				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		0.252	0.245				
T	0.100	0.180		0.140	0.140				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		0.317	0.317				
X	1.250	1.270		1.263	1.257				
Y	1.565	1.585		1.577	1.572				
Z	0.178	0.198							
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓	✓				

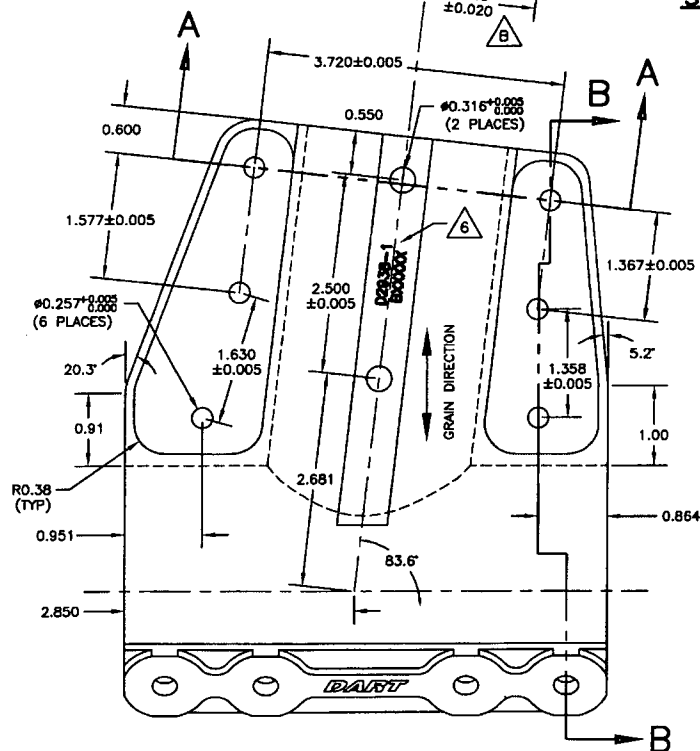
Measured by:	RF
Date:	16/02/24

Audited by:	RF
Date:	16/02/25

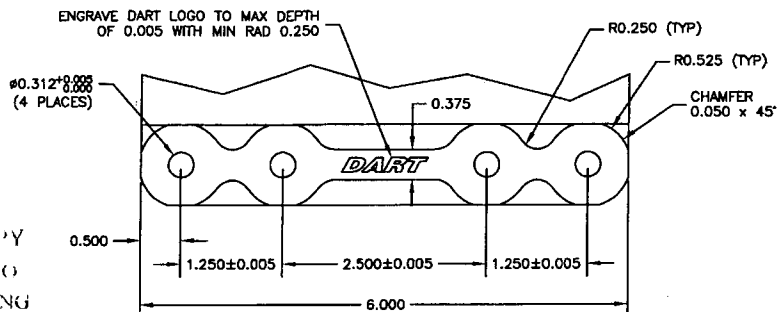
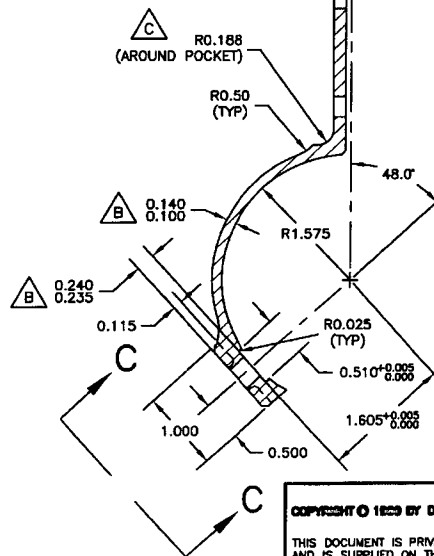
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION A-A



SECTION B-B



VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2938
DATE	TITLE	SADDLE OUTSIDE
06.11.09		

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07.02.12

07.02.12



Part Number: D2938-1	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2938	Work Order: 140964

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
1	1.260	+0.010/-0.010	1.250	1.250	1.250	1.250	1.250
2	0.063	+0.010/-0.010	0.053	0.053	0.053	0.053	0.053
3	0.220	+0.010/-0.010	0.222	0.228	0.228	0.227	0.227
4	1.452	+0.015/-0.015	1.451	1.456	1.455	1.455	1.454
5	0.120	+0.020/-0.020	0.124	0.128	0.127	0.126	0.124
6	0.312	+0.005/0.000	0.312	0.313	0.313	0.313	0.313
7	0.500	+0.010/-0.010	0.502	0.502	0.503	0.500	0.502
8	1.250	+0.005/-0.005	1.250	1.249	1.249	1.249	1.250
9	2.500	+0.005/-0.005	2.500	2.499	2.500	2.500	2.499
10	1.250	+0.005/-0.005	1.249	1.250	1.250	1.250	1.250
11	6.000	+0.010/-0.010	6.001	6.001	6.001	6.001	6.000
12	0.063	+0.010/-0.010	0.059	0.060	0.061	0.061	0.061
Ang13	48.000	+0.500/-0.500	47.741	47.675	47.739	47.725	47.693
14	1.575	+0.010/-0.010	1.573	1.573	1.574	1.574	1.574
15	1.605	+0.005/0.000	1.605	1.605	1.605	1.605	1.605
16	0.500	+0.010/-0.010	0.507	0.510	0.510	0.510	0.510
17	0.500	+0.010/-0.010	0.506	0.510	0.510	0.510	0.510
18	0.115	+0.010/-0.010	0.114	0.114	0.115	0.115	0.115
19	0.235	+0.005/0.000	0.237	0.238	0.238	0.238	0.238
20	0.864	+0.010/-0.010	0.863	0.864	0.863	0.865	0.865
21	5.200	+0.500/-0.500	5.212	5.223	5.216	5.244	5.233
22	1.359	+0.005/-0.005	1.358	1.359	1.359	1.359	1.358
23	1.367	+0.005/-0.005	1.367	1.367	1.367	1.367	1.368
24	0.316	+0.005/0.000	0.316	0.316	0.316	0.316	0.316
25	0.550	+0.010/-0.010	0.549	0.551	0.551	0.551	0.551
26	3.720	+0.005/-0.005	3.719	3.719	3.718	3.719	3.719
27	0.600	+0.010/-0.010	0.598	0.599	0.599	0.599	0.600
28	1.577	+0.005/-0.005	1.577	1.578	1.578	1.576	1.578
29	2.500	+0.005/-0.005	2.500	2.499	2.500	2.500	2.500
30	0.257	+0.005/0.000	0.258	0.258	0.258	0.258	0.258
31	1.630	+0.005/-0.005	1.630	1.629	1.630	1.630	1.630
32	20.300	+0.500/-0.500	20.244	20.247	20.241	20.253	20.243

Measured by:
Mathieu Lamarche

Date:
2016-2-25

Audited by:

Date:



Part Number: D2938-1	Rev: C	- Page 2 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2938	Work Order: 140964

Item Ref.	Nominal	Tolerance	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	No. Piece_5 Actual
33	0.951	+0.010/-0.010	0.953	0.953	0.952	0.952	0.951
34	2.850	+0.010/-0.010	2.851	2.851	2.850	2.851	2.851
35	2.681	+0.010/-0.010	2.683	2.681	2.681	2.681	2.681
36	83.600	+0.500/-0.500	83.568	83.561	83.559	83.566	83.565
D37	0.375	+0.010/-0.010	0.375	0.372	0.375	0.372	0.375
D38	0.050	+0.010/-0.010	0.040	0.042	0.042	0.040	0.040
D39	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	0.188
D40	0.120	+0.020/-0.020	0.113	0.113	0.114	0.115	0.114
D41	0.510	+0.005/0.000	0.512	0.512	0.512	0.513	0.512
D42	0.050	+0.010/-0.010	0.050	0.050	0.050	0.050	0.050
D43	0.120	+0.020/-0.020	0.129	0.128	0.128	0.129	0.127
D44	0.140	+0.040/-0.040	0.140	0.140	0.140	0.140	0.140
D45	0.255	+0.015/-0.015	0.247	0.252	0.252	0.252	0.252
D46	0.625	+0.010/-0.010	0.635	0.635	0.635	0.635	0.635
D47	2.740	+0.020/-0.020	2.740	2.740	2.740	2.740	2.740
D48	0.120	+0.020/-0.020	0.128	0.128	0.128	0.129	0.128

Measured by:
Mathieu Lamarche

Date:
2016-2-25

Audited by:

Date:



Part Number: D2938-1	Rev: C	- Page 1 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2938	Work Order: 140964

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	No. Piece_9 Actual	No. Piece_10 Actual
1	1.260	+0.010/-0.010	1.250	1.250	1.250	1.250	1.250
2	0.063	+0.010/-0.010	0.053	0.053	0.053	0.053	0.056
3	0.220	+0.010/-0.010	0.227	0.227	0.226	0.227	0.219
4	1.452	+0.015/-0.015	1.455	1.454	1.454	1.455	1.442
5	0.120	+0.020/-0.020	0.124	0.123	0.124	0.124	0.114
6	0.312	+0.005/0.000	0.313	0.313	0.313	0.313	0.312
7	0.500	+0.010/-0.010	0.498	0.500	0.500	0.501	0.500
8	1.250	+0.005/-0.005	1.250	1.250	1.249	1.249	1.249
9	2.500	+0.005/-0.005	2.499	2.499	2.499	2.499	2.500
10	1.250	+0.005/-0.005	1.250	1.251	1.250	1.253	1.245
11	6.000	+0.010/-0.010	6.001	6.001	6.001	6.001	5.999
12	0.063	+0.010/-0.010	0.060	0.061	0.061	0.060	0.064
Ang13	48.000	+0.500/-0.500	47.686	47.693	47.716	47.706	47.835
14	1.575	+0.010/-0.010	1.573	1.573	1.573	1.573	1.573
15	1.605	+0.005/0.000	1.605	1.605	1.605	1.605	1.610
16	0.500	+0.010/-0.010	0.510	0.510	0.510	0.510	0.510
17	0.500	+0.010/-0.010	0.510	0.510	0.510	0.510	0.510
18	0.115	+0.010/-0.010	0.114	0.114	0.114	0.114	0.115
19	0.235	+0.005/0.000	0.238	0.237	0.237	0.238	0.238
20	0.864	+0.010/-0.010	0.867	0.866	0.866	0.865	0.864
21	5.200	+0.500/-0.500	5.223	5.210	5.221	5.219	5.213
22	1.359	+0.005/-0.005	1.359	1.359	1.358	1.358	1.359
23	1.367	+0.005/-0.005	1.368	1.368	1.368	1.368	1.368
24	0.316	+0.005/0.000	0.316	0.316	0.316	0.316	0.316
25	0.550	+0.010/-0.010	0.550	0.551	0.551	0.551	0.549
26	3.720	+0.005/-0.005	3.719	3.719	3.719	3.719	3.719
27	0.600	+0.010/-0.010	0.598	0.599	0.598	0.598	0.597
28	1.577	+0.005/-0.005	1.577	1.577	1.577	1.578	1.577
29	2.500	+0.005/-0.005	2.500	2.500	2.500	2.500	2.500
30	0.257	+0.005/0.000	0.258	0.258	0.258	0.258	0.258
31	1.630	+0.005/-0.005	1.630	1.629	1.630	1.629	1.630
32	20.300	+0.500/-0.500	20.239	20.239	20.237	20.249	20.264

Measured by:
Mathieu Lamarche

Date:
2016-2-25

Audited by:

Date:



Part Number: D2938-1	Rev: C	- Page 2 -
Description: SADDLE OUTSIDE	Inspection Dwg: D2938	Work Order: 140964

Item Ref.	Nominal	Tolerance	No. Piece_6 Actual	No. Piece_7 Actual	No. Piece_8 Actual	No. Piece_9 Actual	No. Piece_10 Actual
33	0.951	+0.010/-0.010	0.950	0.951	0.950	0.952	0.952
34	2.850	+0.010/-0.010	2.851	2.851	2.851	2.851	2.850
35	2.681	+0.010/-0.010	2.681	2.681	2.681	2.681	2.681
36	83.600	+0.500/-0.500	83.561	83.559	83.567	83.556	83.565
D37	0.375	+0.010/-0.010	0.375	0.376	0.375	0.375	0.375
D38	0.050	+0.010/-0.010	0.040	0.040	0.040	0.040	0.040
D39	0.188	+0.010/-0.010	0.188	0.188	0.188	0.188	0.188
D40	0.120	+0.020/-0.020	0.115	0.114	0.114	0.113	0.109
D41	0.510	+0.005/0.000	0.512	0.513	0.513	0.512	0.512
D42	0.050	+0.010/-0.010	0.050	0.050	0.050	0.050	0.050
D43	0.120	+0.020/-0.020	0.128	0.128	0.129	0.128	0.127
D44	0.140	+0.040/-0.040	0.140	0.140	0.140	0.140	0.140
D45	0.255	+0.015/-0.015	0.253	0.253	0.253	0.253	0.245
D46	0.625	+0.010/-0.010	0.635	0.635	0.635	0.635	0.635
D47	2.740	+0.020/-0.020	2.740	2.740	2.740	2.740	2.740
D48	0.120	+0.020/-0.020	0.128	0.129	0.129	0.128	0.123

Measured by:
Mathieu Lamarche

Date:
2016-2-25

Audited by:

Date: